

Work Order ID 52929

October 19, 2009 10:58:42 AM

Page 1

Item ID: D3816-1

Revision ID: A

Item Name: Spacer

Start Date: 10/19/09 Start Qty: 16.00

Required Date: 11/02/09 Req'd Qty: 16.00

Reference:

Approvals: Process Plan: *PL*

QC:

Date: *09-10-19*

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3816	Rev A								

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1- Turn as per Folio FA784 Rev: *A* & Dwg D3816 Rev: *A* J2-Deburr per dwg D3816

0.00

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

20 *✓*

20 *✓*

20 *✓*

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Page 2

Item ID: D3816-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacer

Start Date: 10/19/09 Start Qty: 16.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

BR 09-10-20

20



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

UMP 09/10/20

120



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: 115

0.00



Packaging

Memo

0.00

Packaging

CE/10/21 20

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Item ID: D3816-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacer

Start Date: 10/19/09 Start Qty: 16.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/21 *[Signature]*
MF 09-10-21

Picklist Print

October 19, 2009 10:58:48 AM

Work Order ID: 52929

Parent Item: D3816-1RevA

Parent Item Name: Spacer

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.375W.058		Purchased	No			100	f	94.6500	1.6842			



6061-T6 RD Tube .375 x.058W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

94.65

110485

5.67

110968

3.67

111432

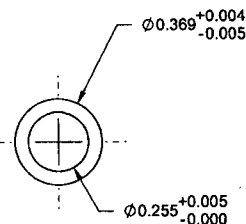
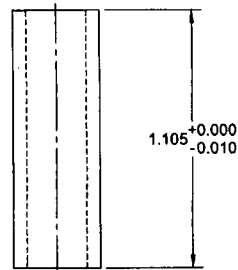
10.21

111944

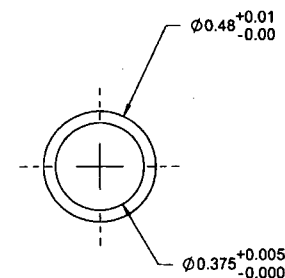
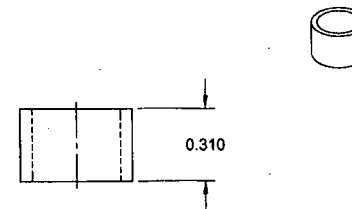
75.1

2.054PT SA 09/10/20

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 52929
BY 09-10-19



D3816-1 SPACER



D3816-3 SPACER

RELEASE
 09/10/19

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6511/T62) ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3816-1/-3 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3816-1 0.01 lbs
 D3816-3 0.01 lbs

A	NEW ISSUE		08.09.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.17		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3816	REV. A
TITLE SPACER	SHEET 1 OF 1
	SCALE NTS

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